

Work Order ID 69819

Thursday, May 19, 2011 2:32:34 PM



Page 1

Item ID: D3492-1

Accept



Setup Start



Revision ID:

Item Name: Plug

Stop



Start Date: 5/19/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/05/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3492

C U/R

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo

1-Turn as per Folio FA633 & Dwg D3492

Dwg Rev:

Folio Rev: N/A

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

100 f

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S 10/13

0.00

R 10/13

100 f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

0.00

100



Small Fab

Small Fab

Memo

1-Deburr if necessary
2-Tumble

0.00

11.5/31

140



QC5- Inspect part completeness to step on W/O

0.00

11.5.21

100



QC

Quality Control

0.00

150



Chemical Conversion Coat per QSI005 4.1

0.00

100



HandFinish

Hand Finishing

Memo

0.00

BL 11-5-1

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

100 ✓ M/F 11/06/06

M 116964

Memo

(Flat End Only)
START TIME:
OVEN TEMPERATURE:
FINISH TIME:

11:45 0.00
320°F
12:15

170

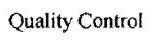


QC3- Inspect Part Finish

0.00

100 ✓ M u/o6/o6

QC



Memo

0.00

Quality Control

180

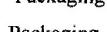


Identify as per dwg & Stock Location: F2-13

0.00

100 ✓ M u/o6/o6

Packaging



Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 5/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

1

n/6/70
MP

11-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 19, 2011 2:32:40 PM

Page 1

Work Order ID: 69819



Parent Item: D3492-1



Parent Item Name: Plug

Start Date: 5/19/2011

Required Date: 5/25/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625 		Purchased	No			100	f	90.0000	0.0625	6.578947		WS/31	

6061-T6 Round Bar .625"

Location	Loc Qty	Loc Code
MAT012	90	
117284	53	
117481	37	

GRJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69819
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>RJ</u>	Audited by:	<u>RJ</u>	Prototype Approval:	N/A
Date:	11/5/21	Date:	11-5-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
C	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD	DS



D
8 7 6 5 4 3 2 1 0
D3492-XX PLUG
(SEE TABLE) NAS1611 O-RING
(SEE TABLE)

C
W/0 69319
C
D3492-XXX PLUG PARTS LIST

QTY	PART NUMBER	DESCRIPTION						
X	041	045	047	049	051	053	D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
							D3492-1	PLUG
							D3492-3	PLUG
							D3492-5	PLUG
							D3492-7	PLUG
							D3492-9	PLUG
							D3492-11	PLUG
							D3492-13	PLUG
							NAS1611-005	O-RING
							NAS1611-007	O-RING
1							NAS1611-010	O-RING
							NAS1611-012	O-RING
							NAS1611-013	O-RING
							NAS1611-015	O-RING
							NAS1611-016	O-RING

A
NOTES:

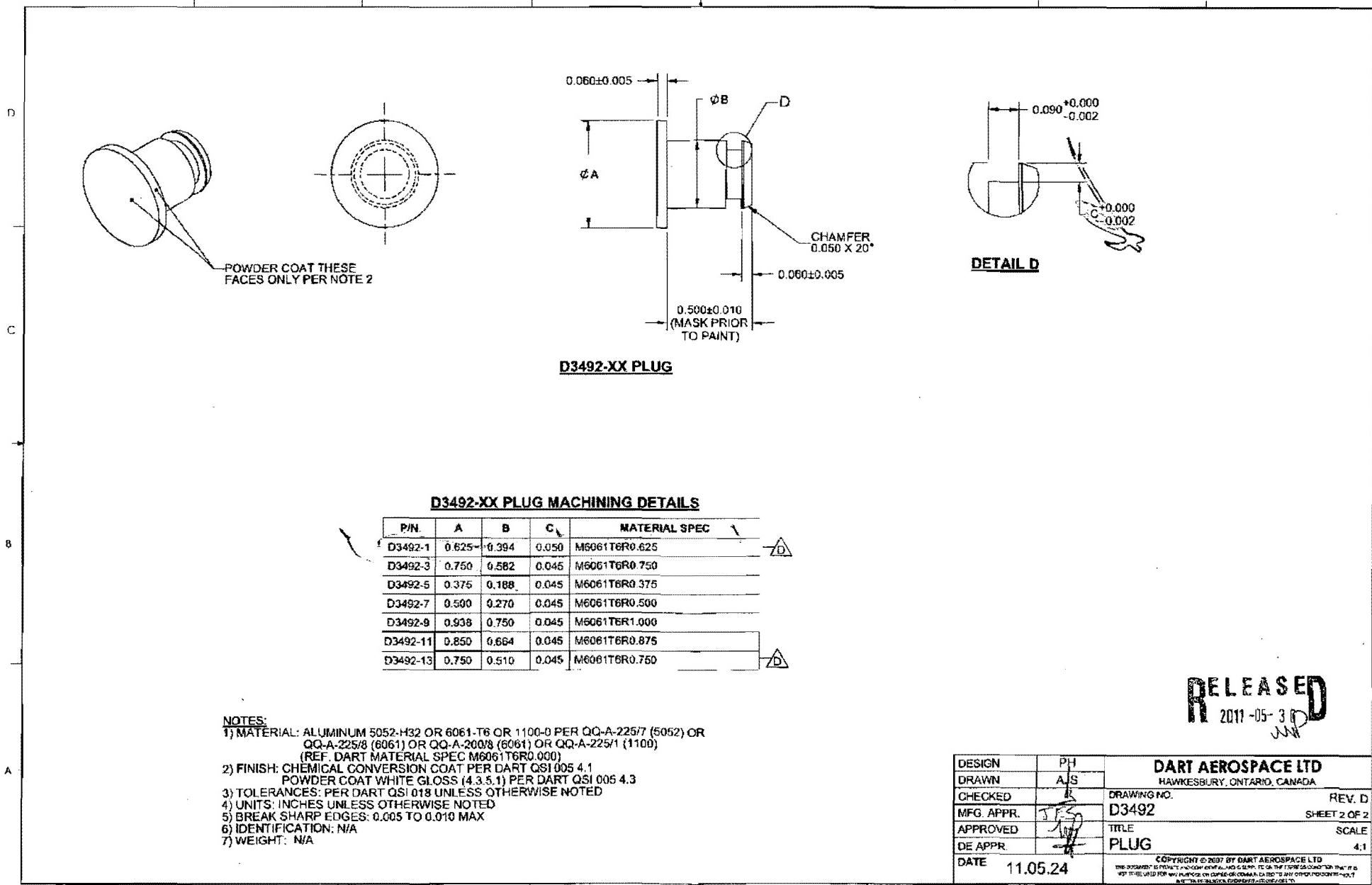
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -3 WAS 0453 (SEE CAR11-048)	AJS	11.05.26
C	ADD -048-0614063, CHANGE DRAWING FORMAT	PH	07.06.06
B	ADD -047: UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A.S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	M	DRAWING NO.	REV. D
MFG. APPR.	J.P.	D3492	SHEET 1 OF 2
APPROVED	A.C.	TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THE DOCUMENT CONTAINS CONFIDENTIAL AND/OR PROPRIETARY INFORMATION OF DART AEROSPACE LTD. NOT TO BE USED OR COPIED EXCEPT AS AUTHORIZED IN AN AGREEMENT RELATING THERETO. UNAUTHORIZED REPRODUCTION HEREBY IS PROHIBITED.	



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

